

Work Order ID 55686

January 27, 2010 11:35:12 AM

HAZ N/A



Item ID: D3954-3

Accept



Setup Start



Revision ID:

Stop



Item Name: GWT Knob

Start Date: 1/27/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3954

B

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3854

Dwg Rev: 8

Prog Rev: B

2-Deburr if necessary

B10-1-27

6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-1-27

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Process Plan:

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Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

28 10/01/07



130



Mill Conv

Conventional Milling Machine

Memo
1-OPEN TO TAP DRILL SIZE
2-TAP AS PER DWG D3954

0.00

0.00

SL 10/01/29

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

28 10/01/29



W 10-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55686

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Cust Item ID:

Required Date: 1/29/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

155

0.00



SprayPaint

Spray Painting

powder coat

Memo

M113544

0.00

1- MASK THREADS PRIOR TO PAINTING AS PER DWG

2- SPRAY PAINT YELLOW AS PER DWG
A/R BATCH: _____

START: 3:15pm J1 10/02/09 (X1) ✓
Temp: 370°F
FIN: 3:45pm

160

QC14- Inspect Spray Paint

0.00



QC

Quality Control

QC3

Memo

0.00

BR 10-02-9



170

Identify as per dwg & Stock Location

0.00



Packaging

Packaging

To stock
Memo

10-02-09

HAJ
SAV
N/A

0.00

102

P10/2/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 55686

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Page 4

Item ID: D3954-3

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Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/02/11

WME
10-2-11

Picklist Print

January 27, 2010 11:35:11 AM

Page 1

Work Order ID: 55686

Parent Item: D3954-3

Parent Item Name: GWT Knob

Comments:

Start Date: 1/27/10

Required Date: 1/29/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M1010B0.375X03.500		Purchased	No			100	f	13.9600	0.0292			



1010-1025 Steel Bar .375 x 3.500



1010-1-27

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

13.96

102179

2.46

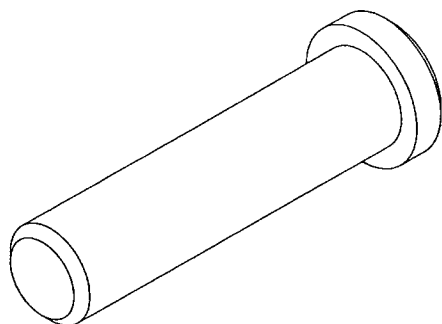
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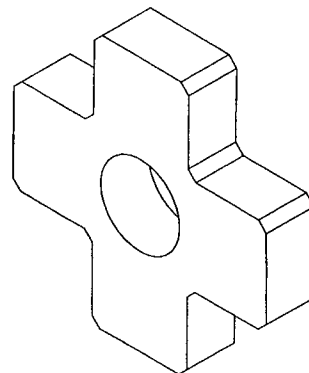
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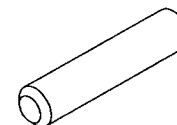
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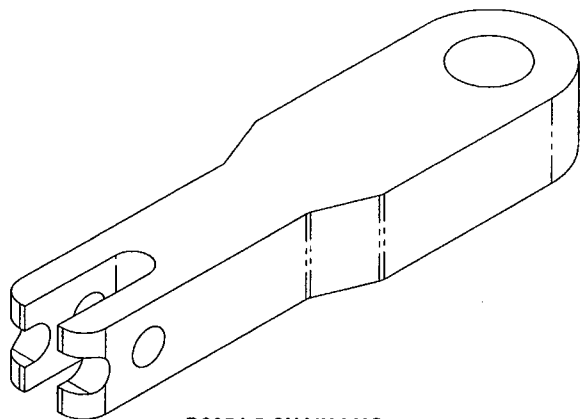
D3954-1 GWT PIN



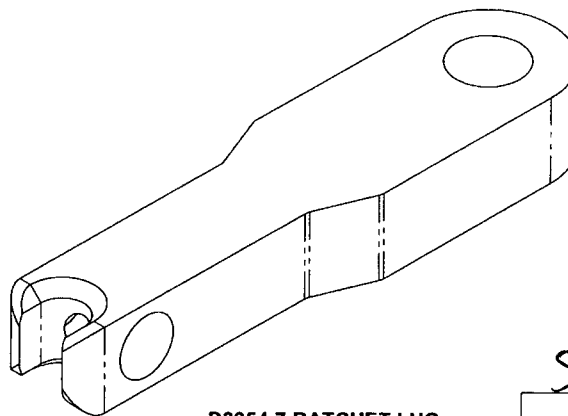
D3954-3 GWT KNOB



D3954-9 GWT CHAIN PIN



D3954-5 CHAIN LUG

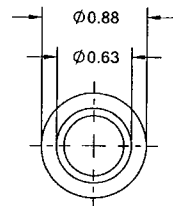


D3954-7 RATCHET LUG

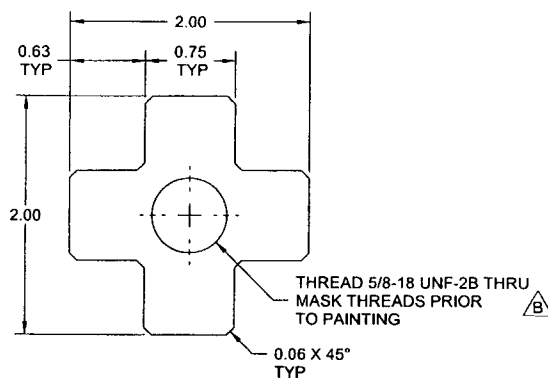
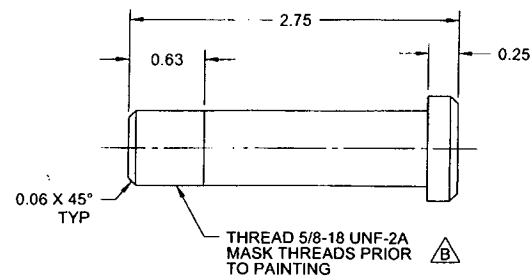
RELEASED
2009-10-19

55686

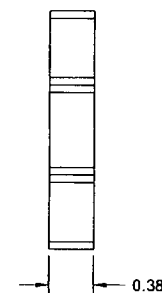
B	MATERIAL UPDATE FOR ALL COMPONENTS WAS STAINLESS STEEL IS CARBON STEEL FOR ALL COMPONENTS. FINISH FOR ALL COMPONENTS WAS RED POWDER COAT IS YELLOW SPRAY PAINT.		AJS	09.10.15
A	NEW ISSUE		AJS	09.05.26
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS/DSTOW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS	DRAWING NO.	REV. B	
CHECKED		D3954	SHEET 1 OF 3	
MFG. APPR.		TITLE	SCALE	
APPROVED		MISC MACHINED PARTS GWT KIT	NTS	
DE APPR.	N/A	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	09.10.15			



D3954-1 GWT PIN



D3954-3 GWT KNOB



NOTES:

1) MATERIAL -1: AISI 1010-1025 MILD STEEL ROUND BAR
PER DART SPEC M1018-R

-3: AISI 1010-1025 MILD STEEL SHEET
PER DART SPEC MS1010-S

OR: AISI 1010-1025 MILD STEEL BAR
PER DART SPEC M1010-B

ALTERNATE MATERIAL:

-1: AISI 303/304 STAINLESS STEEL ROUND BAR
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR
REF DART SPEC M303/304B

- 2) FINISH: SPRAY PAINT YELLOW WITH BERTRAND CG103IB PER DART QSI 005 4.2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -1: 0.26 lbs
-3: 0.23 lbs

RELEASED
2009-10-19

DESIGN	AJS/DSTOW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3954	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.	N/A	MISC MACHINED PARTS GWT KIT	NTS
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